

Date: Wednesday, 2/15/2006 3:50:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG		
Job Number	: 25863					
Estimate Number	: 10008					
P.O. Number	: N/A		Part Number	: D2591		
This Issue	: 2/15/2006 S.O. No. : N/A		Drawing Number	: D2591 REV D		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D		
Previous Run	: 24898		Material	: N/A		
Written By	: SEE COMMENT Below		Due Date	: 3/15/2006 Qty: 30 Um: Each		
Checked & Approved By	: KJ 06.02.16					
Comment	: Est Rev:I Removed from 9 Digit 05-10-25 JLM					

Additional Product

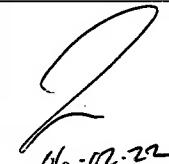
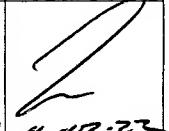
Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"		
		Comment: Qty.: 0.2340 f(s)/Unit Total : 7.0200 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: M19429	SD 06.02.21	
2.0	BAND SAW	BAND SAW		
		Comment: BAND SAW Cut blanks: 2.700" long	SD 06.02.21	(SD)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 2-Deburr if required	JL/SD 06.02.22	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JL/SD 06.02.22	
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	JNL 06.02.23	30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.02.22	3	- [REDACTED] moved while machining	IP 06.02.22 per QSI042	- shift jaws - jaws should be remade - Scarp is destroyed Replaced	SD 06.02.22	 06.02.22	IP 06.02.22 per QSI042	 06.02.22

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 25863

Part Number: D2591

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W510

C 206102124 30

7.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 206102127

Job Completion



6 06-02-27 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25863
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>PG</u>	Prototype Approval:	N/A
Date:	06.02.22	Date:	06.02.22	Date:	N/A

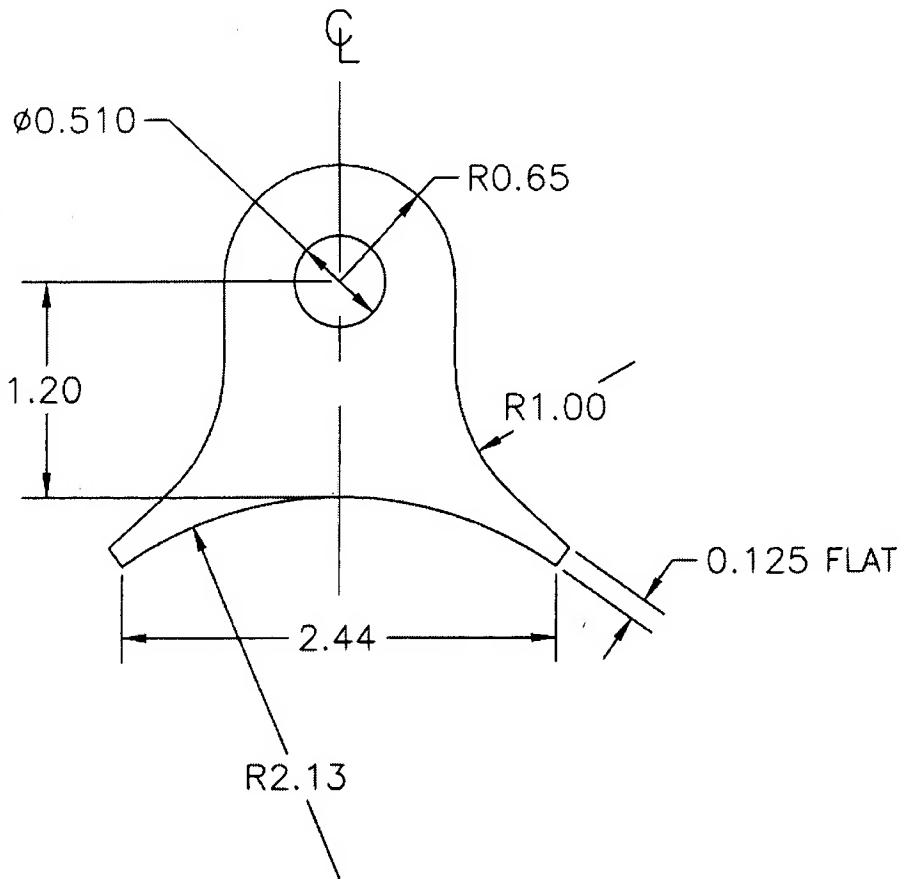
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DS1 9161-011	KJ/JLM	



DR COPY
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO. REV. D D2591 SHEET 1 OF 1
DATE		TITLE SCALE
98.01.21		GHW LUG 1:1
A	96:09:16	NEW ISSUE
B	97:06:17	RE-DESIGN TO FLAT BOTTOM
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM
D	98.01.21	0.125 FLAT WAS 0.067 FLAT

RELEASED
48.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010~~ TO ~~0.020~~

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 25863